

Work Order ID 63681

November 10, 2010 8:51:01 AM

Page 1

Item ID: D3980-041

Accept

Revision ID:

Item Name: Bearpaw Assembly

Start Date: 11/10/10 Start Qty: 10.00

Required Date: 11/15/10 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3980

B

100

0.00



Pick Kit

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

(x16)

Sh.
10/11/24

110

0.00



Assembly

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1- Use wearbar to transfer drill hole and open to finish size as per dwg
2-- Deburr
3- Assemble as per Dwg D3980
4-Install wearplates as per dwg.

(x10)

Sh.
10/11/24

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(x10)

Sh.
10/11/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63681

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Page 2

Item ID: D3980-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw Assembly

Start Date: 11/10/10 Start Qty: 10.00

Required Date: 11/15/10 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Solutu/24

Y10

140



Packaging

Packaging

Identify as per dwg & Stock Location:

RPP

0.00

Memo

G3677

0.00

C10/4/25(10)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/25

PS-0-11-25

10

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2010 8:50:58 AM

Page 1

Work Order ID: 63681

Parent Item: D3980-041

Parent Item Name: Bearpaw Assembly



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev. A New Issue 2010/10/05 DL VERF:DD
change AN4C5A bolt to AN4C6A 2010/11/05 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C5A		Purchased	No			100	Each	978.0000	7	70			
--------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--



Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

ST350	968	
-------	-----	--

114330	11	
--------	----	--

115015	13	
--------	----	--

115371	100	
--------	-----	--

115422	100	
--------	-----	--

115594	282	
--------	-----	--

115835	462	
--------	-----	--

ST351	10	
-------	----	--

113121	10	
--------	----	--

AN4C6A		Purchased	No			100	Each	517.0000	4	40			
--------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--



Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

FG	4	
----	---	--

103344	4	
--------	---	--

ST356	513	
-------	-----	--

113121	63	
--------	----	--

115016	200	
--------	-----	--

116003	200	
--------	-----	--

116075	50	
--------	----	--

Ok.
10/11/24

Ok.
10/11/24

60

10

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 63681

Parent Item: D3980-041

Parent Item Name: Bearpaw Assembly

Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 10.00

Required Qty: 10.00

D3456-1 Manufactured No 100 Each 86.0000 4 40



Washer

Location Loc Qty Loc Code

ST058 86
63239 86 40

D3980-1 Manufactured No 100 Each 0.0000 1 10



429 Bearpaw

D4015-041 Manufactured No 100 Each 56.0000 7 70



Wearbar Weldment

Location Loc Qty Loc Code

ST109 56
53818 45
53956 11

D4211-043 Manufactured No 100 Each 0.0000 1 10



Wearplate, Aft

D4211-045 Manufactured No 100 Each 0.0000 1 10



Wearplate, Aft

MS21043-3 Purchased No 100 Each 2,364.000 7 70



Nut

Location Loc Qty Loc Code

FG 76
103691 76
ST301 2288
112314 2288 70.

Sh
10/11/24

Sh
10/11/24

Sh
10/11/24

Sh
10/11/24

Sh
10/11/24

Sh
10/11/24

November 10, 2010 8:50:59 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 63681

Parent Item: D3980-041

Parent Item Name: Bearpaw Assembly



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 10.00

Required Qty: 10.00

MS21043-4

Purchased

No

100

Each

822.0000

4

40



Nut



Ok.
10/11/24

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

782

112492

25

113069

8

114523

149

114784

300

115936

300

40

NAS1149D0463J

Purchased

No

100

Each

1,857.000

4

40



Washer



Ok.
10/11/24

Location

Loc Qty

Loc Code

ST298

1857

10096

10

114576

68

115622

45

116025

1734

40

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Shop Packet Print

Page 3

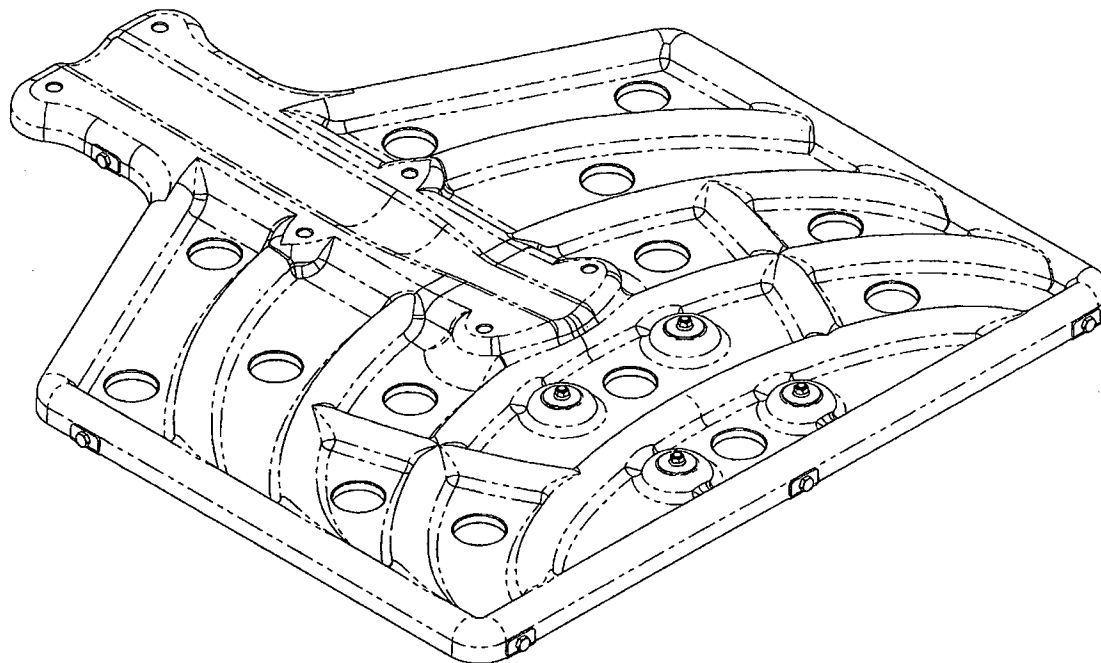
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NOTE: Date & initial all entries



D3980-041 429 ULTRAPAW ASSY

Wlog 268

RELEASED
2010-11-05
JP

B	ULTRAPAW WAS BEARPAW; ADDED D4211-045 WEARPLATE (D4211-043 WAS SEPERATED INTO TWO - ZN AS-2 AND D3-2); REVISED NOTE 9 (A3-3) AND SHADED AREAS (D6-3) BASED ON TR-D429-793-1 REV. A; AN4C8A BOLT WERE AN4C5A BOLT (B5-2 AND D3-2); CORRECTED DIMS AS PER DRILLING JIG (WAS 14.9 (C6-2) AND 0.70 (D4-2)); ADDED RELIEF ON ULTRAPAW NOSE (A6-3, A7-3 AND A8-3).		MB	10.10.25
A	NEW ISSUE		MB	10.09.28
REV.	DESCRIPTION		BY	DATE
DESIGN	DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	MFG. APPR.		DRAWING NO. D3980 REV. B	
APPROVED	DE APPR.		TITLE 429 ULTRAPAW ASSY SCALE NTS	
DATE	10.10.25		COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

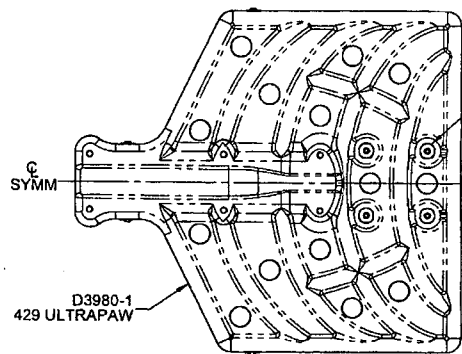
W/O:		WORK ORDER CHANGES					
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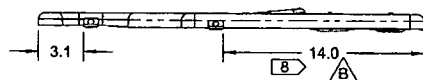
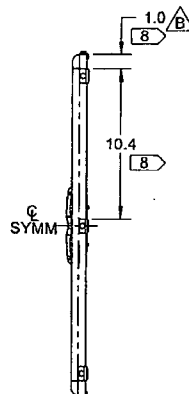
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NOTE: Date & initial all entries



D3456-1 WASHER
MS21043-4 NUT
4 PL



AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

8
9

SYMM

6

D4211-043
AFT WEARPLATE

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

8
9

AN4C6A BOLT
NAS1149D0463J WASHER
4 PL

9

8

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

8
9

D4211-045
AFT WEARPLATE

8
9

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

8
9

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

8
9

D3980-041 429 ULTRAPAW ASSY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3980-041	429 ULTRAPAW ASSY
1	4	D3456-1	WASHER
2	1	D3980-1	429 ULTRAPAW
3	7	D4015-041	WEARBAR
4	1	D4211-043	AFT WEARPLATE
5	1	D4211-045	AFT WEARPLATE
6	7	AN3C5A	BOLT
7	4	AN4C6A	BOLT
8	4	MS21043-4	NUT
9	7	MS21043-3	NUT
10	4	NAS1149D0463J	WASHER

RELEASED
2010-11-03
JWP

D3980-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3980-041" AND B/N "BXXXXX" PER QSI 044 6.4
- 7) WEIGHT: 8.53 lbs
- 8) LOCATE D4015-041 (ITEM 3) AS SHOWN AND TRANSFER DRILL Ø0.191 HOLE FROM D4015-041 TO D3980-1 ULTRAPAW AND FASTEN USING PRESCRIBED HARDWARE.
- 9) TORQUE:
AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO. D3980	REV. B
MFG. APPR.	1		SHEET 2 OF 3
APPROVED	1	TITLE	SCALE
DE APPR.	1	429 ULTRAPAW ASSY	NTS
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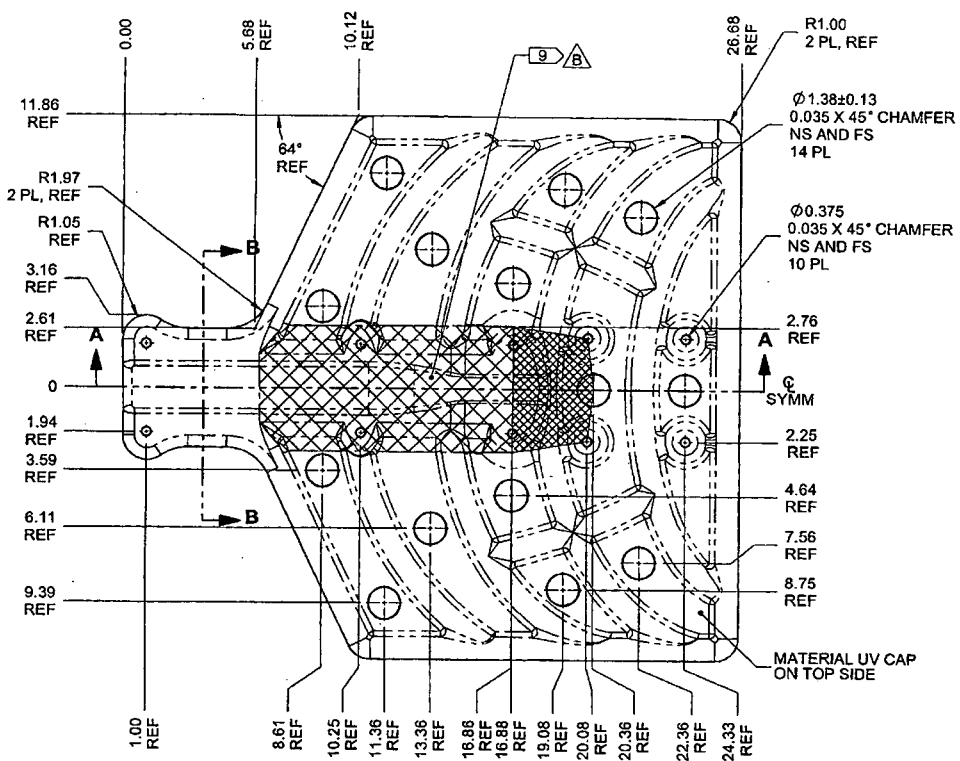
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

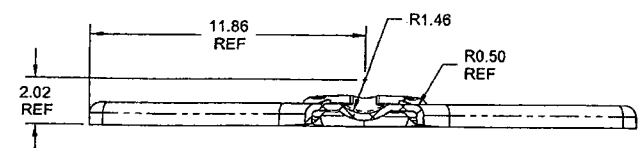
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D3980-1 429 ULTRAPAW



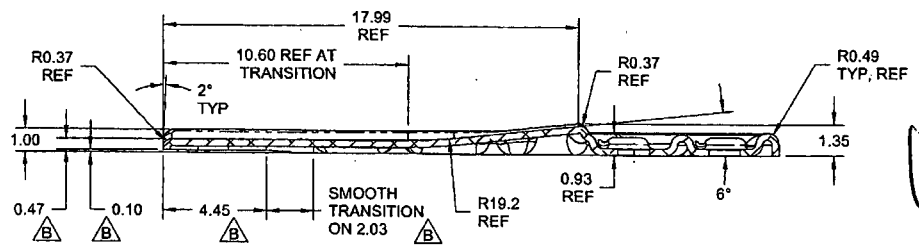
SECTION B-B
VIEW ROTATED 90° CCW

RELEASED
2010-11-03

D3980-1 NOTES:

- 1) MATERIAL: ALEXTRA ET SHEET, 0.300 THICK
REF. DART SPEC. M-ALXTRAB0.300
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.74 lbs
- 8) THERMOFORMING: PER DT9673 AND QSI 022
- 9) MINIMUM THICKNESSES:
☒ = 0.225
☒ = 0.200
☐ = 0.175

63681



SECTION A-A

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3980	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		429 ULTRAPAW ASSY	NTS
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